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D130-1046-113
Job Sheet 196050



Part No: D130-1046-113

Job Qty: 1 pcs

Part Name: EC130T2/H130 Cable Cutter Upper Fixed Provisions



Master Unit
Nº 010570

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/5/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D130-1046 REV.B IPP REV:A 18.02.20 NEW ISSUE DD VERF:JFS IPP REV:B 18.03.13 AS PER IIN
REV.PA7 DD VERF:JFS IPP REV:C 18.08.23 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	6/20/19	6/20/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							→ Packaging 1 - 3	<i>Mon 6-24-19</i>	<i>Oscar</i>
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



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Container No: S193413



Part: D130-1046-113

Job No: 196050

Serial No/Batch: S193413

Revision: B

Inspector:

Exp Date:

Instructions: FAA STC SR02609SE 18/08/09, TC LoA C-18

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	QC 4	1 pcs	6/20/19	0.00 0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	DAS
					QC 4 - 9	75
					QC 4 - 46	9-89
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
130	Packaging 3-1 - Stock - B4B	1 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	75
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135	DC - 1 - B4B	1 pcs	6/20/19	0.00 0.00	DC - 1 - B4B	JUN 27 7:20 AM
					DC - 2 - B4B	
140	QC 21 - FG	1 pcs	6/20/19	0.00 0.00	QC 21 - FG - 21	DAS
					QC 21 - FG - 70	JUN 27 7:20 AM
					QC 21 - SA - 53	70
						9-89
Part Op 110 - Packaging1 (Pick Kit)						
Descriptions: 120 - QC4 (QC4- 100% Inspect kits for completeness)						
130 - Packaging3-1 Identify and pack for shipping as per PPP D130-1046-113 Location: _____						
135 - (Document Control) Photocopy bluefile & type labels per PPP D130-1046-113 CHG001						
140 - QC21 (QC21- Final Inspection - Work Order Release)						

Master Unit N°: 010570

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR7621S-04-02	Rivet, Blind <i>ST 594</i>	11 Ea (11 ea) ✓	110-Packaging 1 - Pick Kit	<i>S134075</i> ✓
CR7621S-04-04	Rivet, Blind <i>ST 594</i>	9 Ea (9 ea) ✓	110-Packaging 1 - Pick Kit	<i>S124564</i> ✓
D5563-1	Placard <i>ST 176</i>	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S067080</i> ✓
D5600-1	Doubler Angle <i>cc.k131</i>	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S123852</i> ✓
D5603-M6-9.5	Insert <i>ST 594</i>	6 pcs (6 ea) ✓	110-Packaging 1 - Pick Kit	<i>S061959</i> ✓
D5604-1	Drill Bushing <i>ST 178</i>	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	<i>S135065</i> ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	CR7621S-04-02	11	36	0
	CR7621S-04-04	9	50	0
	D5563-1	1	49	0
	D5600-1	1	9	0
	D5603-M6-9.5	6	28	0
	D5604-1	1	9	0

Part Specifications

Specifications could not be found.

Plex 6/5/19 9:57 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM	QTY -113	P/N	DESCRIPTION	MANUFACTURER	ALTERNATE PART
	X	D130-1046-113	FIXED PROVISIONS, UPPER, EC130 T2		
1	1	D5600-1	DOUBLER, ANGLE		
2	1	D5563-1	PLACARD		
3	6	D5603-M6-9.5	INSERT		
4	1	D5604-1	DRILL BUSHING		
5	11	MS21141U0402W	MAXIBOLT, BLIND, PAN HEAD		MS21141S0402, CR7621S-04-02
6	9	MS21141U0404W	MAXIBOLT, BLIND, PAN HEAD		MS21141S0404, CR7621S-04-04
7	A/R	PR1422	SEALANT	PPG (DESOTO)	P/S 890 OR MIL-S-8802 COMPLIANT
8	A/R	BJOA0930	BROWN MICROBALLOONS, PHENOLIC (FILLER)	VARIOUS	BJO-0930
9	A/R	EA9396 (PART A&B)	ADHESIVE (BLUE BASE & RED HARDENER)	HENKEL	

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NOTES:

- 1) ALL DIMENSIONS IN MILLIMETERS
- 2) NOT INCLUDED IN KIT. TO BE PROVIDED BY INSTALLER
- 3) LOCATE POSITION FROM D5566-041 CUTTER ASSEMBLY, UPPER.
- 4) INSTALL INSERTS ACCORDING TO THE FOLLOWING INSTRUCTIONS:
 - a) DRILL $\phi 6.1$ THRU PANEL.
 - b) OPEN UP HOLE IN INTERIOR OF AIRCRAFT SKIN TO INSERT DIAMETER, $\phi 17.4$. DO NOT PENETRATE TOP SKIN.
 - c) REMOVE HONEYCOMB CORE BACK TO DIAMETER SHOWN, $\phi 25$ MIN.
 - d) INSTALL INSERT THROUGH BOTTOM HOLE. SECURE USING A SCREW COATED WITH RELEASE AGENT.
 - e) FILL CORE CAVITIES USING ADHESIVE (ITEM 9) AND MICROBALLOONS (ITEM 8).
 - f) CURE THE ADHESIVE AT ROOM TEMPERATURE FOR 24 HOURS.
 - g) REMOVE SCREW SECURING INSERT.
- 5) PICK UP EXISTING RIVETS
- 6) IF D5600-1 DOUBLER (ITEM 1) INTERFERES WITH EXISTING LABEL, INSTALL LABEL APPROXIMATELY AS SHOWN. ENSURE LABEL CONTENT MATCHES LABEL COVERED BY D5600-1 DOUBLER.
- 7) IF THESE RIVETS DO NOT EXIST ON AIRCRAFT, INSTALL PER DIMENSION SHOWN
- 8) IF THESE HOLES ENCROACH ON EXISTING RIVET HOLES LOCATIONS, ELONGATE HOLE IN CANOPY FRAME ONLY TO ENCOMPASS EXISTING RIVET HOLES. DO NOT ELONGATE HOLES IN D5600-1 DOUBLER (ITEM 1).
- 9) IF EXISTING RIVETS INTERFERE, POSITION THESE RIVETS EQUIDISTANT FROM NEIGHBORING RIVETS/HOLES.
- 10) PICK-UP EXISTING RIVET IF POSSIBLE OR LOCATE ON THE AIRCRAFT CENTERLINE.

B	D5563-1 WAS D5601-1 (TYPO)	CP	18.06.26
A	NEW ISSUE	AJS	18.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	JMH	DART AEROSPACE USA, INC.	
DRAWN	CP	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	N/A	D130-1046-113	SHEET 1 OF 4
APPROVED	DSW	TITLE	FIXED PROVISIONS, UPPER, SCALE
DE APPR.	CP	EC130 T2	NTS
DATE	18.06.26	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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